








# Work Order ID 51904

Wednesday, September 09, 2009 11:07:15 A

Page 1

Item ID: D2572 Accept  Setup Start   
 Revision ID: E Stop   
 Item Name: Saddle, Fwd In 205  
 Start Date: 9/11/2009 Start Qty: 6.00  Cust Item ID:  
 Required Date: 9/18/2009 Req'd Qty: 6.00  Customer:

## Reference:

Approvals: Process Plan: BC2 Date: 09-9-09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2572	Rev E

100

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

### Memo

Program Batch No. 51904

Double check by: \_\_\_\_\_

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

0.00

110

0.00



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

### Memo

Machine keyway as per dwg D2571 & D2572

0.00

**Work Order ID 51904**

Wednesday, September 09, 2009 11:07:15 A

Page 2

Item ID: D2572

Accept

Revision ID: E

Item Name: Saddle, Fwd In 205

Setup Start

Stop

Start Date: 9/11/2009 Start Qty: 6.00

Required Date: 9/18/2009 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

amf 09/10/21

6

8

QC

Memo

Quality Control

130

QC8- Inspect parts - second check

0.00

0.00

mms  
09/10/21

6

8

QC

Memo

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

BR 09-10-21

6

HandFinish

Memo

Hand Finishing

[illegible]

Page 3



**Stop**

**Abstract**

**Abstract**

**Required Date:** 9/18/2009      **Req'd Qty:** 6.00

**Customer:**

**Reference:**

Run Start



**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

3

**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Insp.  
Stamp**

0.00

11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32

M112260

0.00

**Powdercoat**

## Memo

## Powder Coating

START TIME: 8:00am ☐

OVEN TEMPERATURE: 320°F ☐

FINISH TIME: 8:30AM

0.00

**Abstract**

0.00

QC

## Memo

## Quality Control

0.00

\_\_\_\_\_

0.00

### Packaging

## Memo

## Packaging

**Work Order ID 51904**

Wednesday, September 09, 2009 11:07:15 A

Page 4

Item ID: D2572

Accept

Revision ID: E

Item Name: Saddle, Fwd In 205

Start Date: 9/11/2009 Start Qty: 6.00

Required Date: 9/18/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09-10-27  
MF 09-10-24

# Picklist Print

Page 1

Wednesday, September 09, 2009 11:07:22 AM

Work Order ID: 51904



Parent Item: D2572RevE



Parent Item Name: Saddle, Fwd In 205

Start Date: 9/11/2009

Required Date: 9/18/2009

Comments:

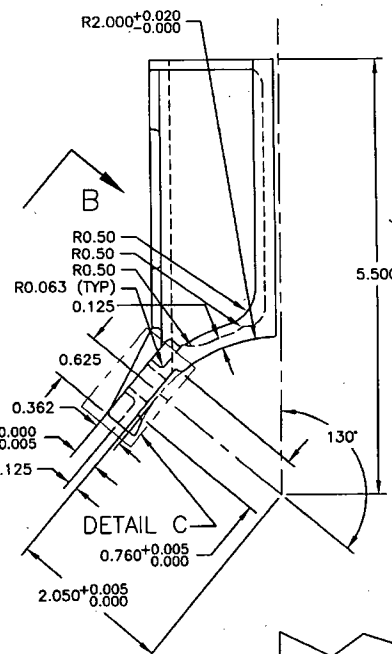
Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005RevB		Manufactured	No			100	Each	0.0000	6.0000			
Saddle Billet												

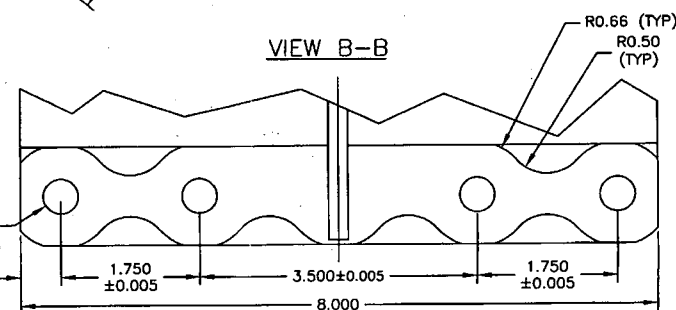
~~Batch~~  
Batch# B46411      *mk* 09/10/20      6

05.12.06 ~~11~~



MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER: COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E






DETAIL C  
SCALE 2:1

WITHOUT NOTICE  
WORK CONTINUED

NO. 51904

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AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS	DRAWN BY PH	 <b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2572
DATE 05.07.13		TITLE INNER FWD SADDLE

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 51904	
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b> D2572	
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.441	.440	.439	.439		
B	1.745	1.755		1.750	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.499	3.499	3.499		
D	1.745	1.755		1.750	1.749	1.750	1.749		
E	7.990	8.010		8.003	8.003	8.001	8.000		
F	0.490	0.510		.498	.500	.501	.500		
G	0.257	0.262		.258	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.502	.503	.502		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		.570	.571	.570	.570		
L	1.174	1.184		1.180	1.179	1.179	1.180		
M	1.490	1.500		1.497	1.494	1.494	1.496		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.875	3.875	3.875		
P	0.115	0.135		.122	.123	.123	.121		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.246	.250	.251	.251		
S	0.115	0.135		.128	.126	.127	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.964	2.960	2.964	2.962		
V	0.230	0.250		.235	.240	.240	.238		
W	0.115	0.135		.127	.123	.124	.129		
X	0.307	0.312		.311	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.357	.366	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.626	.626	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.388	1.386	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.245	.253	.250	.251		
AI	2.000	2.020		2.002	2.000	2.000	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SP / [Signature]
Date:	02/10/18 / 09/10/20

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM [Signature]	[Signature]

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 51904
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> <del>D2571</del> D2572
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	26	3	4	By	Date
A	0.438	0.443		.439	.440				
B	1.745	1.755		1.749	1.749				
C	3.495	3.505		3.499	3.500				
D	1.745	1.755		1.749	1.749				
E	7.990	8.010		8.001	8.001				
F	0.490	0.510		.501	.501				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.377	.378				
I	0.490	0.510		.500	.501				
J	1.174	1.184		1.180	1.177				
K	0.558	0.578		.569	.569				
L	1.174	1.184		1.180	1.177				
M	1.490	1.500		1.496	1.493				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.871				
P	0.115	0.135		.123	.122				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.251	.257				
S	0.115	0.135		.130	.129				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.962	2.960				
V	0.230	0.250		.238	.239				
W	0.115	0.135		.130	.128				
X	0.308	0.313		.312	.312				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.366	.365				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.626	.626				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.245				
AE	1.375	1.395		1.386	1.385				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.253				
AH	0.240	0.260		.248	.248				
AI	2.000	2.020		2.001	2.001				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: <i>JS</i>
Date: 09/10/19 / 09/10/21

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	